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D4930-3
Job Sheet 185998



Part No: D4930-3

Job Qty: 6 ea

Part Name: Bearpaw



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/8/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP REV:A NEW ISSUE 13-10-09 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	6 pcs	11/30/18	11/30/18	0.00	1.76	Waterjet - Flow	DAS 52	OK 18/11/19
120	CNC Vertical Machining	6 pcs	11/30/18	11/30/18	0.49	8.45	HAAS1-5	52	19/01/09
140	QC	6 pcs	11/30/18	11/30/18	0.00	0.00	QC8	9-89	19/01/05
150	Packaging	6 pcs	11/30/18	11/30/18	0.00	0.00	Packaging3	54511A	JAN 07 2019
160	QC21-SA	6 Ea	11/30/18	11/30/18	0.00	0.00	QC21	DAS 21	JAN 07 2019

Part Op 110 - CUT BLANK AS PER FILE D4930-3 BLANK

Descriptions: 120 - 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FB218 and Dwg

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	10.8000 sf (1.8 ea)	110-Waterjet - Flow - 1	5045598

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	MUHMWB10	11	583	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bearpaw	0.380Inches ± 0.030	0.410 0.350		0.38
2	Bearpaw	2.380Inches ± 0.030	2.410 2.350		2.38
3	Bearpaw	0.260Inches + 0.006 - 0.001	0.266 0.259	Diameter	Ø .260
4	Bearpaw	4.250Inches ± 0.010	4.260 4.240		4.250
5	Bearpaw	5.870Inches ± 0.010	5.880 5.860		5.87
6	Bearpaw	1.083Inches ± 0.010	1.093 1.073		1.083
7	Bearpaw	3.850Inches ± 0.010	3.860 3.840		3.850

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

8	Bearpaw	14.760Inches ± 0.030	14.790 14.730	14.760
9	Bearpaw	5.500Inches ± 0.030	5.530 5.470	5.500
10	Bearpaw	0.250Inches ± 0.030	0.280 0.220	Radius 0.25
11	Bearpaw	0.070Inches ± 0.030	0.100 0.040	0.06
12	Bearpaw	45.000Degrees ± 0.500	45.500 44.500	Angle 45°
13	Bearpaw	2.170Inches ± 0.030	2.200 2.140	2.160
14	Bearpaw	0.250Inches ± 0.030	0.280 0.220	0.257
15	Bearpaw	0.630Inches ± 0.030	0.660 0.600	0.640
16	Bearpaw	0.950Inches ± 0.010	0.960 0.940	0.950
17	Bearpaw	0.130Inches ± 0.030	0.160 0.100	0.13
18	Bearpaw	45.000Degrees ± 0.500	45.500 44.500	Angle 45°
19	Bearpaw	0.525Inches ± 0.010	0.535 0.515	0.532
20	Bearpaw	0.375Inches ± 0.010	0.385 0.365	0.380
21	Bearpaw	1.300Inches ± 0.030	1.330 1.270	1.300
22	Bearpaw	5.700Inches ± 0.030	5.730 5.670	5.700
23	Bearpaw	10.500Inches ± 0.030	10.530 10.470	10.500
24	Bearpaw	14.140Inches ± 0.030	14.170 14.110	14.140
25	Bearpaw	0.450Inches ± 0.030	0.480 0.420	0.46
26	Bearpaw	0.880Inches + 0.010 - 0.001	0.890	0.884

19/01/02
DAS
52
9.89

vt.lajeunesse.marie

DART
AEROSPACE

Container No: S130370
Part: D4930-3
Job No: 185998
Serial No/Batch: S130370

Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Date: 11/22/18

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www.dartaero.com

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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